

Date: Thursday, 15/01/2009 11:15:16 AM
 User: Julie Dawson

Process Sheet

Split

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : PANEL-350 FWD CANOPY
 Job Number : 44821
 Estimate Number : 13099
 P.O. Number :
 This Issue : 15/01/2009 S.O. No. :
 Prsht Rev. : NC Part Number : D36563
 First Issue : 1/1 Type : THERMOFORMING Drawing Number : D3656 REV B
 Previous Run : 43889 Drawing Revision : B
 Material :
 Due Date : 10/02/2009 Qty: ① Um: ② Each
 Written By :
 Checked & Approved By : JUD 09.01.15
 Comment : Est. Rev. A 07/12/13 New Issue DL verified by:DD
 Est. Rev. B 08/09/25 Dwg. Update DL

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 MLEXS093F600607 GE PLASTICS LEXAN SHEET



Comment: Qty.: 34.6600 sf(s)/Unit Total : 138.6400 sf(s)

GE PLASTICS LEXAN SHEET

batch: M107574 BB 09/01/24

2.0 HAND FINISH TH HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Cut Blanks to fit frame size BB 09/01/24 (X4)

3.0 THERMOFORMING THERMOFORMING MACHINE



Comment: THERMOFORMING MACHINE

Thermoform as per Dwg. D3656-3 and Folio FTA 016 using tool DT8987

Dwg. Rev. B

Folio Rev. C BB 09/01/24 (X4)

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Visually inspect for proper formation of each part BB 09/01/24 (X4) P10

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: D3656-3 PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: 12 Date: 09-01-29
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: <u>44821</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>09/01/26</u>	<u>3.0</u>	<u>2 Parts did not form properly (NEW Mould)</u> <u>Adjust Settings</u>	<u>[Signature]</u> <u>09/01/26</u>	<u>Scrap 2 parts, adjust settings and update folio,</u>	<u>09/01/28</u> <u>Wh.</u>	<u>[Signature]</u> <u>09/01/28</u>	<u>[Signature]</u> <u>09/01/28</u>	<u>[Signature]</u> <u>09/01/28</u>
		<u>Re: Development.</u>						

NOTE: Date & initial all entries

Date: Thursday, 15/01/2009 11:15:16 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PANEL-350 FWD CANOPY

Job Number: 44821

Part Number: D36563

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

S 09/01/26

6.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Trim to Finished Dimensions as per dwg D3656

BB 09/01/26 (X1)

7.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Check dimensions to ensure conformity to drawing tolerances.

BB 09/01/26 (X1)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/01/26

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

PPP44641

SS 09/01/27 (X1)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/01/28

Job Completion



W 09/01/27

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 44821
Description: Panel		Part Number: D3656-3
Inspection Dwg: D3656	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Shape Definition	✓			
Free of visual flaws (bumps, cracks, voids, etc.)	✓			

Measured by: BB

Date: 09/01/26

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.040	Min	.049	✓			
0.045	Min	.066	✓			
0.050	Min	.062	✓			

Measured by: BB

Date: 09/01/26

Audited by: S

Date: 09/01/26

Prototype Approval:

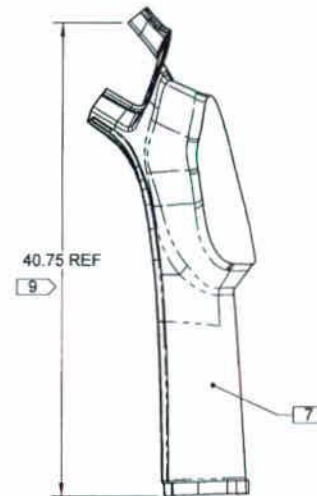
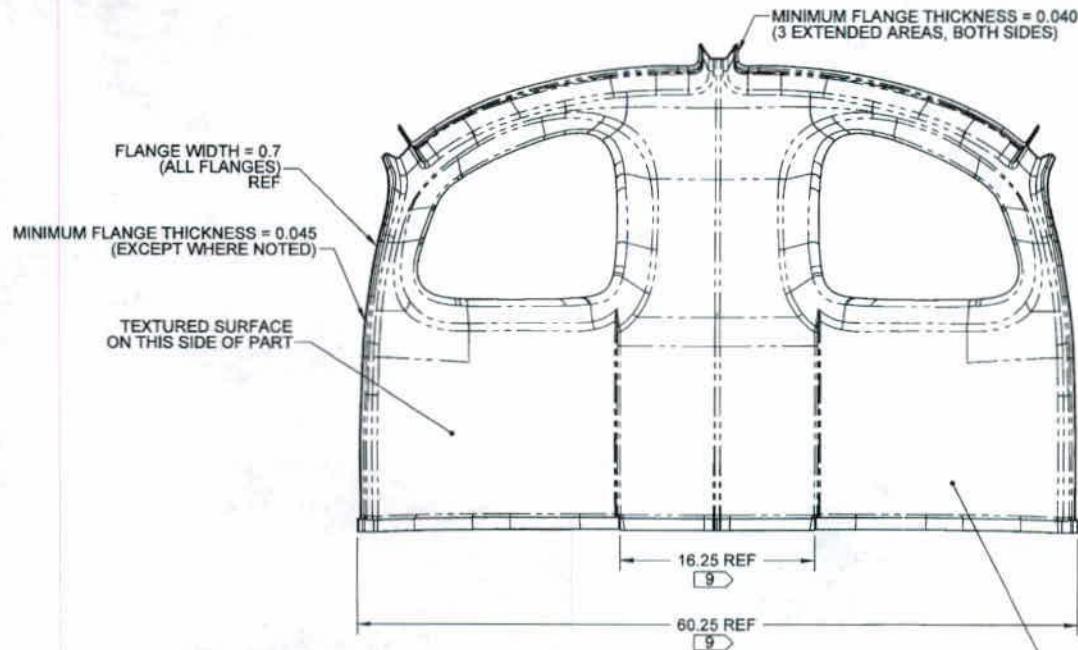
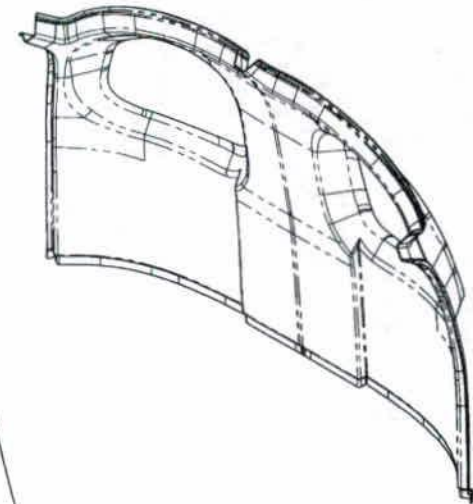
N/A

Date:

N/A

Rev	Date	Change	Revised by	Approved
A	08.05.28	New Issue	KJ/DL	

REFERENCE ONLY



D3656-3 PANEL

NOTES:

- 1) MATERIAL: F6006 SUEDE/POLISHED GY5B133 LIGHT GREY LEXAN SHEET 0.093 THICK (REF DART SPEC MLEXS.093-F6006-07)
- 2) TOOLING: THERMOFORM PER MOLD DT8987 PER QSI 022 TRIM PER DT8987
- 3) FINISH: NONE
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: ETCH P/N AND B/N ON SMOOTH SIDE OF PART
- 8) WEIGHT: 8.7 lbs
- 9) DIMENSIONS TAKEN WITH PART IN MOLD WHERE INDICATED

12874 PM 44821

RELEASED
06-09-3010

ASED

DESIGN	LE	DART AEROSPACE LTD	
DRAWN	AF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	5	DRAWING NO.	REV. B
MFG. APPR.	5	D3656	SHEET 2 OF 2
APPROVED	5	TITLE	SCALE
DE APPR.	5	PANEL	NTS
DATE	08.09.18	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRELIMINARY AND CONFIDENTIAL. IT IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSES OF REPRODUCTION OR TRANSMISSION IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			